

Date: Wednesday, 5/31/2006 7:39:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STA 84 BRACKET		
Job Number	: 27302		Part Number	: D28032		
Estimate Number	: 11035		Drawing Number	: D2803 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/31/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A Type : MACHINED PARTS		Due Date	: 6/18/2006 Qty: 20 Um: Each		
Previous Run	: 26588					
Written By	: See J.F. Comment, Below					
Checked & Approved By	: J.F. 06.05.31 N					
Comment	: Est. A 00.11.06 New Issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
		 Comment: Qty.: 2.0125 f(s)/Unit Total : 40.2507 f(s) 6061-T6 Bar .50" x 10.0" Material: 6061-T6 bar 10.00" x 0.50" Batch: M100285
2.0	BAND SAW	 Comment: BAND SAW Cut blanks per template DT8533
3.0	HAAS1	 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA102
4.0	QC2	 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
6.0	SMALL FAB 1	 Comment: SECOND CHECK
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

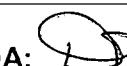
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 DQA: 

Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 27302

Part Number: D28032

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/1/06/10

20

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5/11 06/06/10

20

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST156

11/12/06 (20)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/13 (20)

Job Completion



U 06/06/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27302
Description: Bracket	Part Number:	D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.F.	Audited by:	SA	Prototype Approval:	N/A
Date:	06/06/08	Date:	06.06.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	✓

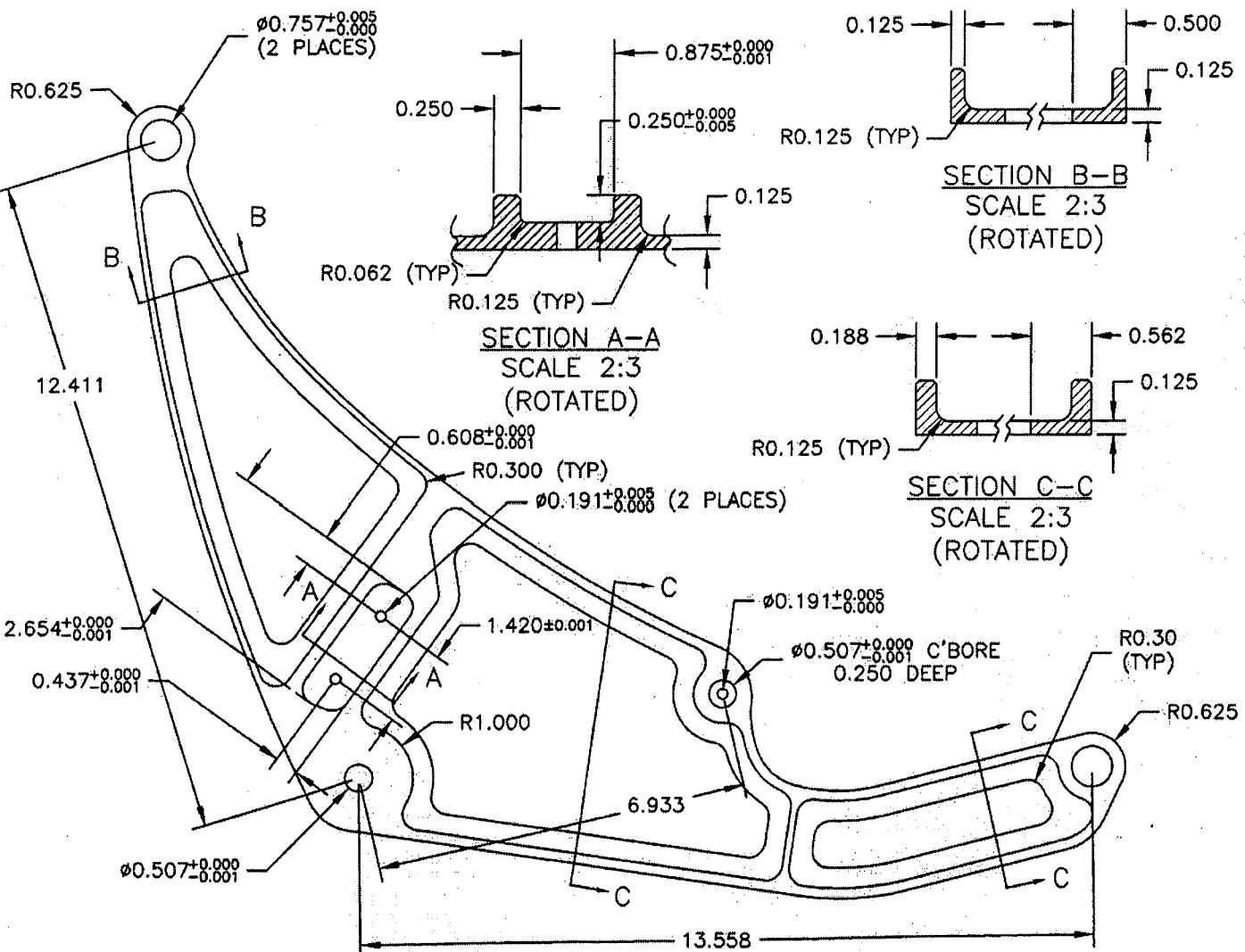
DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3

RELEASED

05.03.11 -

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

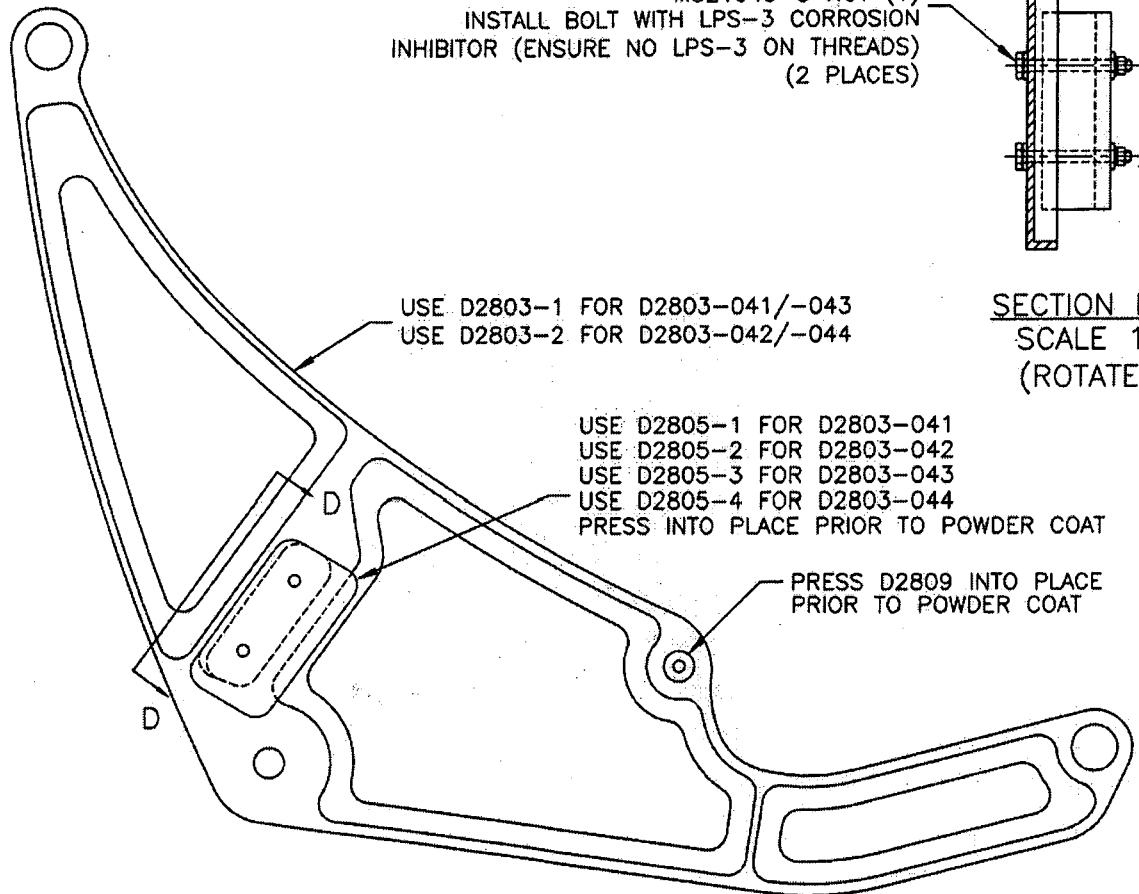
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NO. 27302

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2803
DATE		TITLE
04.11.22		STA 84 BRACKET
		SCALE
		1:3



D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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